

Work Order ID 73853

Friday, September 16, 2011 12:50:07 PM



Page 1

Item ID: D2662-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2662

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ Inspect part number and batch number are programmed correctly. ☐ Fixturing Inspection last completed _____ by _____
☐ Machine Step No 1 of Folio and inspect per attached Dimension Sheet ☐ Machine Step No 2 of Folio

JK 11-11-04

15

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

JK 11-11-04

15

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

JK 11-11-04

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>mk 11/16/11</i>		<u>15</u>	<u>0</u>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>15</u>	<u>0</u>	<u>11-11-11</u>	
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*M 118439**3200F**9:10**15X 0 M-11/16/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Item ID: D2662-2

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Setup Start



Revision ID:

Stop



Item Name: Saddle, RH In 206

Start Date: 9/16/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				15	BR	11-11-8.	
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				152	11/11/9		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/11/10

mr
11-11-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 12:50:04 PM

Page 1

Work Order ID: 73853



Parent Item: D2662-2



Parent Item Name: Saddle, RH In 206

Start Date: 9/16/2011

Required Date: 11/4/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.11.01 Removed P/O for Powder Coat - in house process EC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	49.0000	1	10			
Saddle Billet													

Location	Loc Qty	Loc Code
MAT040	49	
64777	20	
66965	1	
69677	2	
70976	10	
72225	16	

73779

74648

6

11/9

2 11-10-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 73853
Description: 206 Saddle, Inboard, Right side	Part Number: D2662-2
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121	.120	.120	.120	.120	
B	0.100	0.140		.133	.132	.133	.133	.132	
C	1.125	1.145		1.140	1.140	1.139	1.140	1.139	
D	0.615	0.685		.680	.680	.680	.680	.680	
E	0.240	0.260		.248	.248	.248	.248	.248	
F	1.313	1.343		1.325	1.325	1.324	1.324	1.323	
G	0.210	0.230		.220	.220	.219	.219	.220	
H	0.100	0.180		.140	.140	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.580	1.580	1.579	1.580	1.579	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.113	.113	.113	.113	.113	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.797	.797	.797	.797	.797	
W	0.540	0.560		.550	.550	.550	.549	.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.921	.922	.922	.921	.921	
AA	0.490	0.510		.503	.502	.500	.500	.501	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	11-11-03

Audited by:	mf
Date:	11/11/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	73853
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					Date
Dim	Min	Max	Go/No Go Gauge	1/6	1/4	3/8	1/2	5/8	
A	0.100	0.140		.120	.120	.120	.120	.120	
B	0.100	0.140		.132	.132	.132	.133	.132	
C	1.125	1.145		1.139	1.140	1.139	1.139	1.139	
D	0.615	0.685		.680	.680	.680	.680	.680	
E	0.240	0.260		.247	.247	.248	.248	.248	
F	1.313	1.343		1.323	1.323	1.324	1.324	1.324	
G	0.210	0.230		.220	.220	.220	.220	.220	
H	0.100	0.180		.140	.140	.140	.140	.140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.579	1.580	1.579	1.579	1.579	
K	0.235	0.240		.238	.238	.238	.238	.238	
L	0.100	0.120		.113	.113	.113	.113	.113	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		.512	.512	.512	.512	.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		.313	.313	.313	.313	.313	
S	0.315	0.322		.316	.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		.797	.797	.797	.797	.797	
W	0.540	0.560		.550	.551	.550	.550	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		.257	.257	.257	.257	.257	
Z	0.912	0.932		.921	.921	.921	.922	.921	
AA	0.490	0.510		.501	.501	.501	.501	.501	
AB	0.178	0.198		.188	.188	.188	.188	.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>
Date:	11-11-03	Date:	11/11/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order:	73853
Description: 206 Saddle, Inboard, Right side		Part Number:	D2662-2
Inspection Dwg: D2662 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1)	12	13	14	By 15	Date
A	0.100	0.140		-120	-120	-120	-120	-120	
B	0.100	0.140		-132	-133	-132	-132	-133	
C	1.125	1.145		1.139	1.140	1.140	1.140	1.139	
D	0.615	0.685		-680	-680	-680	-680	-680	
E	0.240	0.260		-247	-248	-248	-248	-249	
F	1.313	1.343		1.324	1.324	1.323	1.325	1.325	
G	0.210	0.230		-220	-220	-219	-220	-220	
H	0.100	0.180		-140	-140	-140	-140	-140	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.579	1.580	1.580	1.580	1.579	
K	0.235	0.240		-238	-238	-238	-238	-238	
L	0.100	0.120		-113	-113	-113	-113	-113	
M	0.990	1.010		1.000	1.000	1.000	1.000	1.000	
N	0.510	0.515		-512	-512	-512	-512	-512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		-313	-313	-313	-313	-313	
S	0.315	0.322		-316	-316	-316	-316	-316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		-797	-797	-797	-797	-797	
W	0.540	0.560		-550	-550	-549	-549	-550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		-257	-257	-257	-257	-257	
Z	0.912	0.932		-921	-922	-922	-921	-922	
AA	0.490	0.510		-500	-500	-503	-501	-502	
AB	0.178	0.198		-188	-188	-188	-188	-188	
AC									
AD									
AE									
AF									
Accept/Reject									

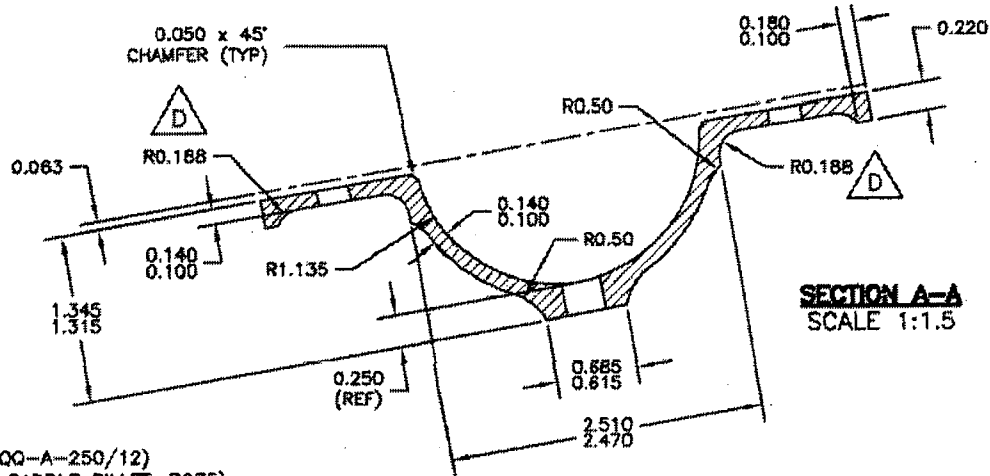
Measured by:	<i>X</i>	Audited by:	<i>amp</i>
Date:	11-11-03	Date:	11/11/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>



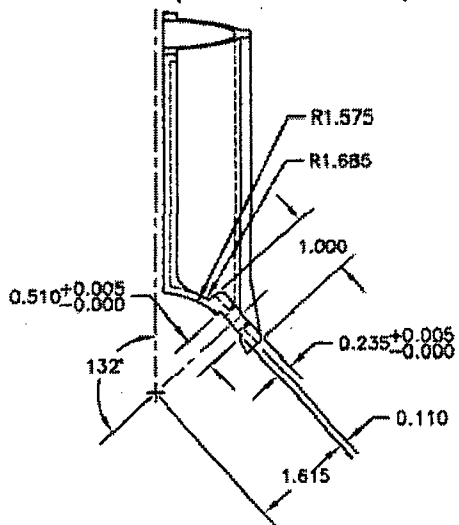
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE INSIDE		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	RO.188 WAS RO.30; Ø0.316 WAS Ø0.313	

RELEASED
07.02.12 **#**

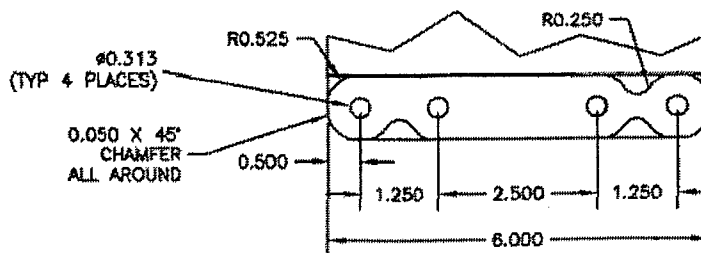
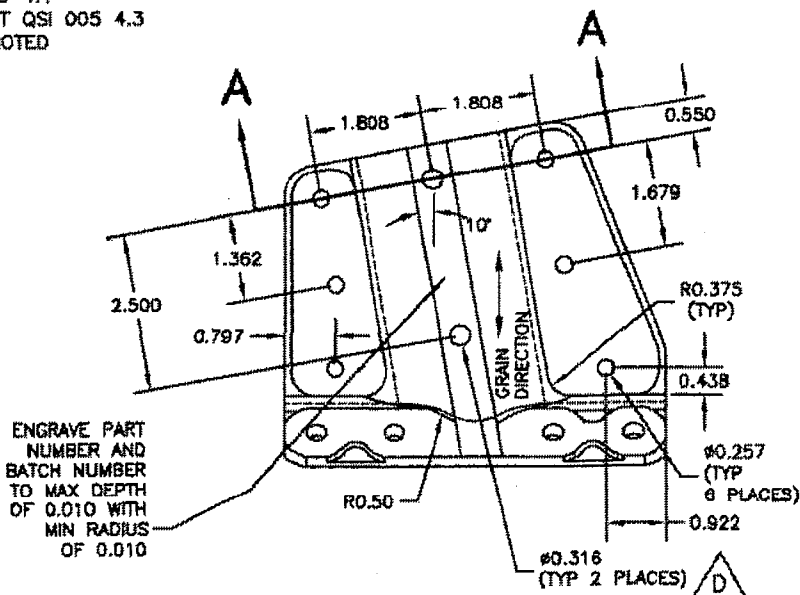


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)



D2662-1 SADDLE INSIDE



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